

Work Order ID 147888***147888***

Page 1

Friday, June 17, 2016 7:54:00 AM

Item ID: D5343-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Hook
Start Date: 6/30/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 6/30/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: JUN 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D5343	A								

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 32789
Possible supplier: Victory Spring
Manufacture as per Dwg
Description: Long Hook

Material release note is required.

26.67

20JUN 21 2016**DAS**
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.07

20X 80/6-75

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Work Order ID 147888

Friday, June 17, 2016 7:54:00 AM

147888

Page 2

Item ID: D5343-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Hook

Start Date: 6/30/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/30/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.07							DAS 38 8-89 JUL 08 2016
Quality Control									
130	Identify as per dwg & Stock Location: <u>2443</u>	0.00							
130									
Packaging	Memo	0.03							21 JUL 13 2016 DAS 6 8-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.33							16/7/13 JF
Quality Control									

DAS
21
8-89

JUL 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, June 17, 2016 7:53:59 AM

Page 1

Work Order ID: 147888

147888

Parent Item: D5343-1

D5343-1

Parent Item Name: Long Hook

Start Date: 6/30/2016

Required Date: 6/30/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 16.06.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5343-1P

Purchased

No

Each

0.0000

D5343-1P

Long Hook

**

20

20 OK 8/2/6-7-5

DQA: _____ Date: _____

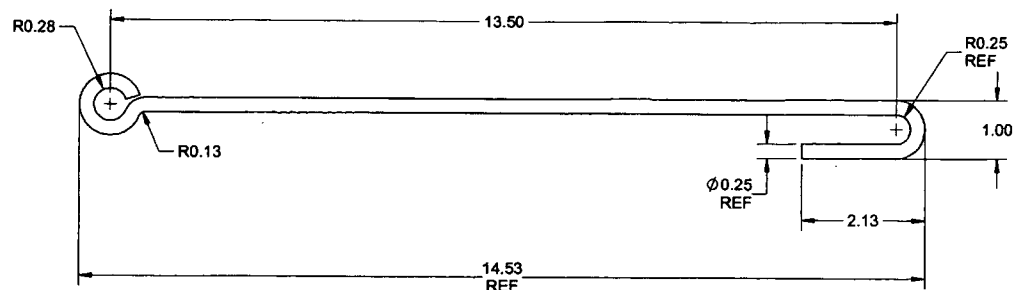


WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER :									



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

D5343-1 LONG HOOK

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR, $\phi 0.25$ ", FULL HARD
 PER ASTM A276
 REF DART SPEC M304R0.250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.7
- 7) WEIGHT: 0.26 lbs

147888 MWS
 1606-17

RELEASED
 2016-06-03
 3016-533

APPROVED

A		NEW ISSUE		VS	15.10.09
REV.		DESCRIPTION		BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	VS				
CHECKED	AK	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5343	SHEET 1 OF 1		
APPROVED	DW	TITLE	SCALE		
DE APPR.	DS	LONG HOOK	NTS		
DATE		15.10.09		COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32789

Purchase Order Date 6/21/2016 3:21:15 PM

PO Print Date 6/21/2016

Page Number 1 of 2

Order From :
VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

VC-VIC002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

JUN 21 2016

Contact Name
Vendor Phone 866 230 5312

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D5343-IP	Long Hook	6/30/2016 Yes 6/30/2016	FN	20.00 Each	\$14.85	\$297.00
	AS PER DWG D5343 REV. A B147888						
						Line Total:	\$297.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	6/30/2016 No 6/30/2016		1.00	\$0.00	\$0.00
		Procurement Quality Clauses A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) A016 PERSONNEL QUALIFICATION A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS					

Note:

6/21/2016



#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
e + accounts@victoryspring.ca

PACKING SLIP

Packing Slip: 35399
Date: Jun 29, 2016
Order Ref: PO32789

Sold to:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship to:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Shipped By: FedEx

Shipped Quantity	Backorder Quantity	Unit	Item No.	Description	Price
20		Each	-	D5343-1P Long Hook <i>SP/6-75</i>	14.85
Comment:					

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace	DATE: 6/29/2016
PART/DRAWING #: D5343-1P	PO # PO23625
DESCR: Long Hook	QUANTITY: 20

VICTORY SPRING CERTIFIES BY THIS DOCUMENT THAT ALL OPERATIONS ARE DONE ACCORDING TO
DRAWINGS AND SPECIFICATIONS

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	AISI 304/316 SS	AISI 302	
Material diameter	0.250"	0.250"	
Coil I.D.	R0.28"	R0.30"	
Hook O.D.	1.00"	1.04"-1.06"	
Overall Length	14.53 ref	14.5" -14.56"	
Hook Length	2.13"	2.09"-2.15"	

Mill Certificate attached: Yes
Material Heat Number: 41824

Inspected by: Jeremy Burrowes - QA

Jeremy Burrowes

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace	DATE: 6/29/2016																																																							
PART/DRAWING #: D5343-1P	PO # PO32789																																																							
SPRING DESCRIPTION: Long Hook	QUANTITY: 20																																																							
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03																																																								
PROPERTIES: <table> <thead> <tr> <th colspan="3"><u>Chemical</u></th> <th colspan="2"><u>Physical</u></th> </tr> </thead> <tbody> <tr> <td>Carbon:</td> <td>(C)</td> <td>0.069</td> <td>Size:</td> <td>0.250"</td> </tr> <tr> <td>Chromium:</td> <td>(Cr)</td> <td>18.120</td> <td></td> <td></td> </tr> <tr> <td>Copper:</td> <td>(Cu)</td> <td>0.350</td> <td>Tensile PSI:</td> <td>186,000</td> </tr> <tr> <td>Manganese:</td> <td>(Mn)</td> <td>1.070</td> <td></td> <td></td> </tr> <tr> <td>Molybdenum:</td> <td>(Mo)</td> <td>0.230</td> <td></td> <td></td> </tr> <tr> <td>Nickel:</td> <td>(Ni)</td> <td>8.070</td> <td></td> <td></td> </tr> <tr> <td>Nitrogen:</td> <td>(N)</td> <td>0.080</td> <td>Heat #</td> <td>41824</td> </tr> <tr> <td>Phosphorus:</td> <td>(P)</td> <td>0.036</td> <td></td> <td></td> </tr> <tr> <td>Silicon:</td> <td>(Si)</td> <td>0.300</td> <td></td> <td></td> </tr> <tr> <td>Sulphur:</td> <td>(S)</td> <td>0.001</td> <td></td> <td></td> </tr> </tbody> </table> Mill Source: Sumiden Origin Country: USA		<u>Chemical</u>			<u>Physical</u>		Carbon:	(C)	0.069	Size:	0.250"	Chromium:	(Cr)	18.120			Copper:	(Cu)	0.350	Tensile PSI:	186,000	Manganese:	(Mn)	1.070			Molybdenum:	(Mo)	0.230			Nickel:	(Ni)	8.070			Nitrogen:	(N)	0.080	Heat #	41824	Phosphorus:	(P)	0.036			Silicon:	(Si)	0.300			Sulphur:	(S)	0.001		
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Certified by: Jeremy Burrowes - QA

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.